

Date: Tuesday, 4/15/2008 2:35:35 PM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CAP
Job Number :	38605		
Estimate Number :	11627		
P.O. Number :		Part Number :	D2965
This Issue :	4/15/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2965 REV B
First Issue :	//	Project Number :	N/A
Previous Run :	36033	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :		Due Date :	4/16/2008
Comment :	Est: A 00.05.31 New Issue EC Est Rev: Added Turning as per Rev B 06-12-15 JLM		

Qty: 4 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O

Cast per Dwg D2965

Material Release Note Required

2.0	D2965P	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Cap

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Drill as per Dwg D2965 with DT8538

Deburr and Tumble

N/A
 blue from stock

B/N 36033

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



N/A



Comment: DIMENSIONAL CHECK

7.0

POWDER COATING

POWDER COATING



M107550



Comment: POWDER COATING

Mask as per Dwg D2965

Powder To match Skidtube(Ref: 4.3.5.x) as per QSI 005 4.3

FL 08/04/15 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M. 08/04/16 (4X)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

M100621

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

M. 08/04/16 (4X)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2965

M. 08/04/16 (4X)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 08 04 16 (4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A M. 08/04/18 (4X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 38605

Part Number: D2965

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/22

[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-04-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

PORT HADLOCK, WA

REV. B

SHEET 1 OF 2

SCALE

DRAWING NO.	D2965
TITLE	

APPROVED *[Signature]*

CHECKED

DATE _____

05.11.01

TITLE

CAF

A

00.02.24

NEW ISSUE

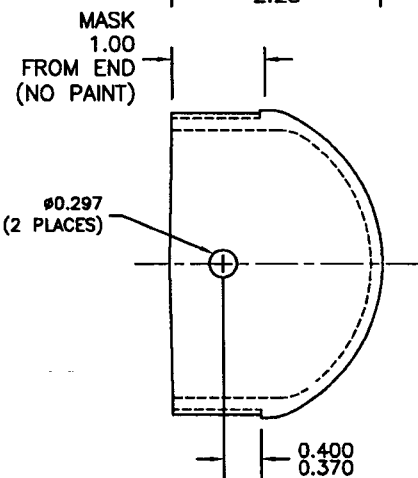
W

06.11.01

ADD -3 CAP

RELEASE

06.12.12 ~~4~~



Technical drawing of a circular part with the following dimensions and tolerances:

- Top horizontal dimension: 0.405
- Top-left vertical dimension: 0.188 (upper), 0.125 (lower)
- Top-right radius: R0.50 (TYP)
- Right-side diameter: $\phi 3.330$ (upper), $\phi 3.300$ (lower)
- Right-side thickness: 0.188 (upper), 0.125 (lower)
- Left-side vertical dimension: 3.150 (upper), 3.120 (lower)
- Bottom-right angle: 45°

INSTALL AELS-1032-225 INSERT
(2 PLACES)

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

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0808/04115

1.210' 38605